

Date: Tuesday, 4/18/2006 10:02:39 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : ARM
<b>Job Number</b> : 26671	
<b>Estimate Number</b> : 11376	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D33872
<b>This Issue</b> : 4/18/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3387 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 26162	<b>Material</b> : N/A
<b>Written By</b> : <u>See Comment Below</u>	<b>Due Date</b> : 5/2/2006
<b>Checked &amp; Approved By</b> : <u>06.04.18</u>	<b>Qty:</b> 10 <b>Um:</b> Each
<b>Comment</b> : Est:A 05.06.10 New Issue KJ/JLM Est:B 06.03.22 Split c'sink op. EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
-----	--------------------	-------------------------



**Comment:** Qty.: 1.5680 f(s)/Unit Total : 15.6797 f(s)  
 6061-T6 Bar .50" x 6.0"  
 Material: 6061-T6/T651 (QQ-A-200/8)  
 (M6061T6B0.500x06.000)  
 Identify for D3387-2  
 Batch: M100817

ML 06/04/29 10

2.0	BAND SAW	BAND SAW
-----	----------	----------



**Comment:** BAND SAW  
 Cut blank: 6.000" x 0.500" x 17.800" long

ML 06/04/29 10

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA512 and Dwg D3387  
 Identify as D3387-2  
 Tumble and Deburr NO sharp edges

ML 06/04/29 10

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



**Comment:** CONVENTIONAL MILLING MACHINE  
 C'sink Ø0.375" as per Dwg D3387

ML 06/04/29 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: 15 Date: 06/05/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:02:39 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 26671

Part Number: D33872

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*File 06/04/27 10*

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*SP 06/04/30 16*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA30*

*RE. 06-05-1*

10

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*SP 06/05/01 (10)*

Job Completion



*u 06-05-01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	26671
<b>Description:</b> Arm		<b>Part Number:</b>	D3387-2
<b>Inspection Dwg:</b> D3387 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.501	—			
7.577	+/-0.010	7.581	—			
R0.030	+/-0.010	R0.030	—			
Ø0.191	+0.005/-0.000	Ø0.191	—			
1.700	+/-0.010	1.701	—			
0.188	+/-0.010	0.190	—			
11.405	+/-0.010	11.405	—			
Ø0.507	+0.000/-0.001	Ø0.5066	—			
2.033	+/-0.005	2.033	—			
R0.300	+/-0.010	R0.300	—			
1.000	+/-0.005	1.000	—			
2.000	+/-0.010	2.000	—			
1.347	+/-0.005	1.347	—			
0.250	+/-0.010	0.251	—			
R0.125	+/-0.010	R0.125	—			
0.125	+/-0.010	0.132	—			
R0.032	+/-0.010	R0.032	—			
Ø0.375 x100°	+/-0.010	Ø0.375x100	—			
0.500	+/-0.010	0.493	—			
0.300	+/-0.010	0.298				

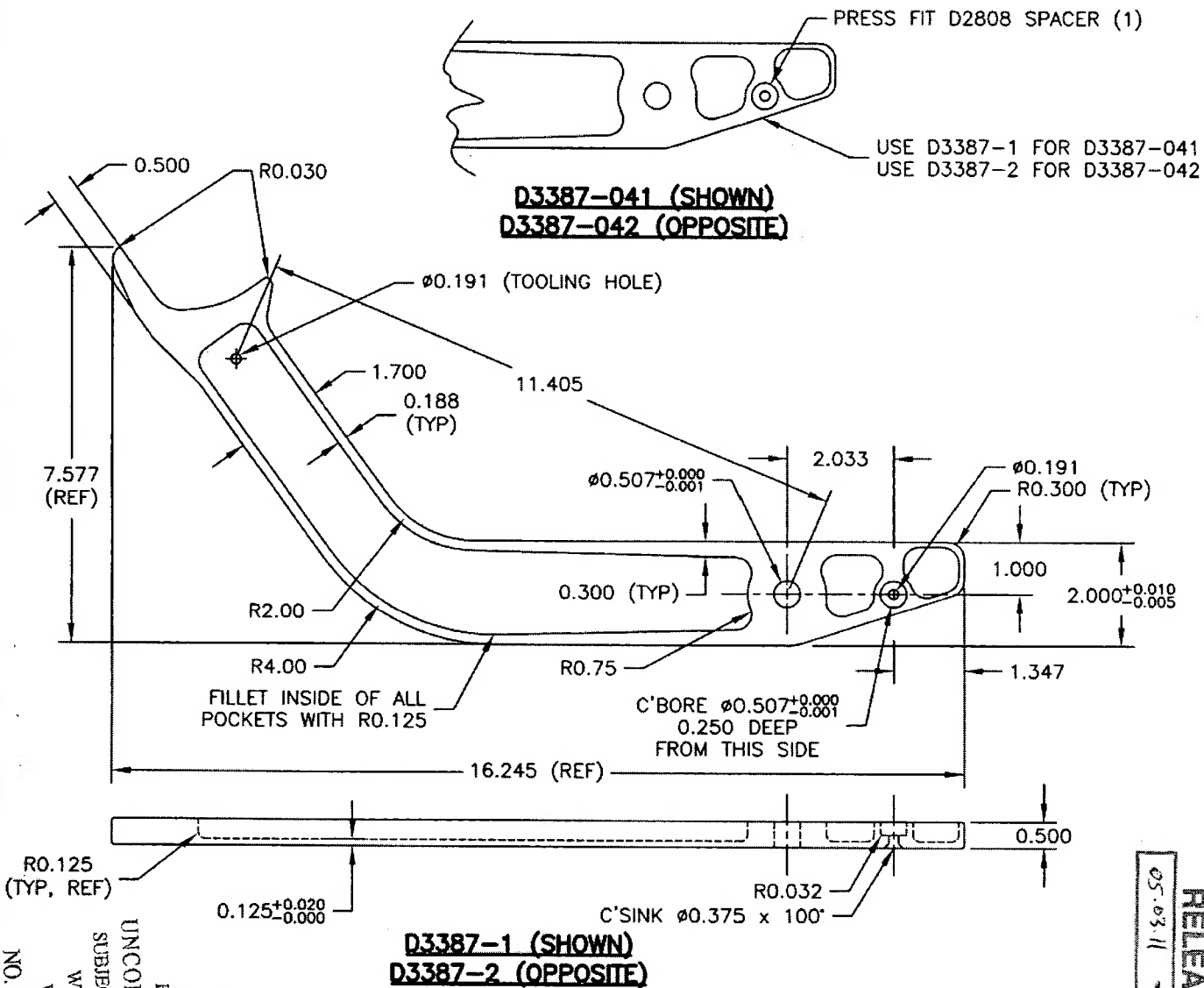
<b>Measured by:</b>	<i>ML</i>	<b>Audited by:</b>	<i>EP</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/04/29	<b>Date:</b>	06/04/29	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM <i>AK</i>	<i>Jul</i>

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A	
DATE		D3387	SHEET 1 OF 1	
05.01.18		TITLE	SCALE	
		ARM	1:3	
A		05.01.18	NEW ISSUE	

05.03.16



## GENERAL NOTES

- 1) MACHINE PER DRAWING FILE "D3387-A.DWG"  
2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK  
(REF DART SPEC. M6061T6B0.500)  
3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26671

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Copyright © 2005 by DART AEROSPACE LTD